

March 17, 2010 4:39:46 PM

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Run Start



Date 10-3-17

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Draw Nbr	Revision Nbr
D2580	Rev D

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

110

0.00

BENDING MACHINE - SKIDTUBES

CNC Bend 1

0.00

CNC Delta 100 Bender

Memo

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

N/A ~~OK~~

MB/D (X) MB 10-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57041

March 17, 2010 4:39:46 PM



Page 2

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 17/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 06/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends								
	2- C'sink holes as per dwg without cutting fluid								
	3- Prepare tube for welding, remove alodine as required.								
	4- Scribe batch number insied aft end of tube.								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

(4)

BE 10/03/29

S 10/03/29

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D205-634-041

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Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 17/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 06/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod *m113207**BE 10/03/30*

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod *m113207**BE 10/03/30*

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Debur holes*BE 10/03/30*

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID 57041

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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 17/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 06/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	8.0.0.03/30						
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8.0.0.03/30			(H)			
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00 0.00	br 10-H-1			①.			

W/O:		WORK ORDER CHANGES					
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Work Order ID 57041

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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 17/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 06/04/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M 11B170
3:30
320°
4:00

0.00

BR 10-4-5

①

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

M 10/4/06

①

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 57041

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Item ID: D205-634-041
Revision ID:
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 17/03/2010 Start Qty: 1.00
Required Date: 06/04/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of
Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 M 112429
Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as
per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with
Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 M 112429
Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M 113462

BF 10-4-7 ①

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 57041

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Item ID: D205-634-041
Revision ID:
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 17/03/2010 Start Qty: 1.00
Required Date: 06/04/2010 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00 0.00	8 do 4/07			(+L)			
220 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____ PPN 57619	0.00 0.00							PC 10/04/14 + (1)
230 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/04/14 mf 10-4-14

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Page 1

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Work Order ID: 57041

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 17/03/2010

Required Date: 06/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2580-1 Manufactured No 110 Each 6.0000 1.0000



205 Skidtube bent detail



B-56795 MB 10-03-29

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	6	
54541	2	
56667	2	
56767	2	

D2576-3 Manufactured No 140 Each 127.0000 1.0000



Step (maching detail)



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	127	
46661	80	
52215	47	

1 BE 10/03/30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 57041



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 17/03/2010

Required Date: 06/04/2010

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2579 Manufactured No 140 Each 188.0000 20.0000



Crossbolt Spacer



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	188	
43988	4	
46434	4	
46956	2	
47797	9	
48272	2	
51314	71	
51315	30	
51525	4	
53780	3	
54543	18	
56715	41	

856818

(x20)

BE 10/03/30

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 17/03/2010

Required Date: 06/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2855



Cap

Manufactured No 200 Each 139.0000 1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP6	1	
56613	1	
Main Warehouse		
ST026	138	
50513	1	
50770	1	
51539 ✓	37	
53791	99	

1 BR 10-4-7

AN3-5A



Bolt

Purchased No 200 Each 1,397.000 2.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST350	1397	
100188	188	
105057 ✓	1209	

2 BR 10-4-7.

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Page 3

W/O:		WORK ORDER CHANGES					
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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 17/03/2010

Required Date: 06/04/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L

Purchased No

200

Each

3,025.000 2.0000



Washer

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST348

3025

101291

16

105793

49

110985 ✓

2960

ALS7-1032-130

Purchased

No

200

Each

986.0000 50.0000



Insert

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST282

986

108606

52

111529

130

111779

34

112772

11

113238 ✓

759

2 BL 10-4-7

50 BL 10-4-7

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 17/03/2010

Required Date: 06/04/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

200

Each

1,193.000 50.0000

BOLT

Warehouse

Location

Main Warehouse

ST350

Loc Qty

Loc Code

1193

112314

13

112720

12

112724

3

112829

1

112991

2

113121

64

113226

244

113644

12

113749

11

114103

331

114108

500

50 BR 10-4-7.

March 17, 2010 4:39:51 PM

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 17/03/2010

Required Date: 06/04/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

Purchased

No

200

Each

388.0000

50.0000



washer



Warehouse

Loc Qty

Loc Code

Location

NAS1149C0332R OFFSHORE 113524

FG

100

103585

100

Main Warehouse

ST

288

112116

128

112612

160

D3566-13

Manufactured

No

200

Each

66.0000

1.0000



Gasket



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

64

53461 ✓

64

Main Warehouse

ST

2

45717

1

50265

1

50, BR 10-4-7

1 BR 10-4-7

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W/O:		WORK ORDER CHANGES					
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Page 7

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 17/03/2010

Required Date: 06/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-5



Gasket

Manufactured No 200 Each 14.0000 1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP19	11	
55335 ✓	11	
Main Warehouse		
ST	3	
36113	1	
46186	1	
51260	1	

1 BL 10-11-7

D3566-1



Gasket

Manufactured No 200 Each 19.0000 2.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP 36825	14	
52512	3	
54480	1	
55011	1	
56532	9	
Main Warehouse		
ST	5	
46349	1	
51218	1	
51259	3	

2 BL 10-11-7

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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 57041

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 17/03/2010

Required Date: 06/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-11



Wearshoe

Manufactured No 200 Each 5.0000 1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP19	3	
56834 ✓	3	
Main Warehouse		
ST	2	
45823	1	
50112	1	

1 BR 10-4-7.

D3564-13



Wearshoe

Manufactured No 200 Each 27.0000 1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP17	15	
56285 ✓	15	
Main Warehouse		
ST	12	
45409	2	
46495	10	

1 BR 10-4-7.

March 17, 2010 4:39:51 PM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 57041

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments:

IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 17/03/2010

Required Date: 06/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-9



Wearshoe

Manufactured No 200 Each 12.0000 1.0000



Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	FP19	11	
	55334 ✓	11	
Main Warehouse	ST	1	
	44659	1	

1 BL 10-4-7

D3564-5



Wearshoe

Manufactured No 200 Each 26.0000 1.0000



Warehouse	Location	Loc Qty	Loc Code
OFFSHORE	FG	2	
	34806	2	
Main Warehouse	FP19	23	
	55024 ✓	11	
	55333	12	
Main Warehouse	ST	1	
	45824	1	

1 BL 10-4-7.

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 17, 2010 4:39:51 PM

Page 10

Work Order ID: 57041

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 17/03/2010

Required Date: 06/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2594-3



O-Ring, 205 Skidtube

Manufactured No 200 Each 420.0000 16.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	420	
51613	27	
52562	13	
55546 ✓	380	

10 PR 10-4-7

D2594-1



Plug, 205 Skidtube

Manufactured No 200 Each 513.0000 16.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	513	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	6	
54008	1	
54643	15	
55002 ✓	369	

10. PR 10-4-7.

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.06.28 #

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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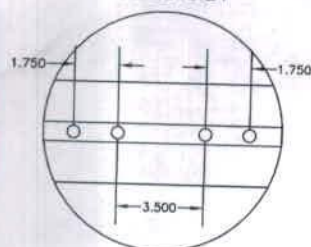
WORK ORDER

NO. 5704

B/KO-329

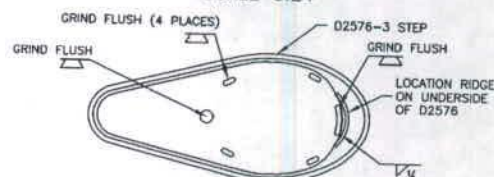


DETAIL A
SCALE 5:24

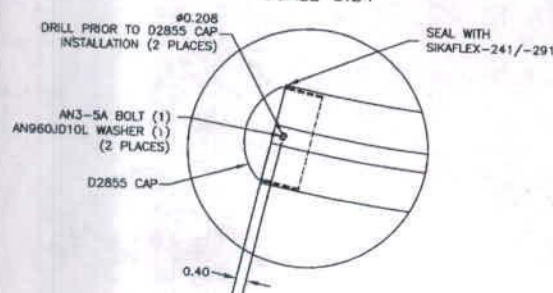


RELEASED
07-06-88

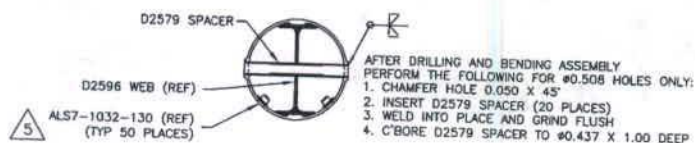
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SCALE 5:24



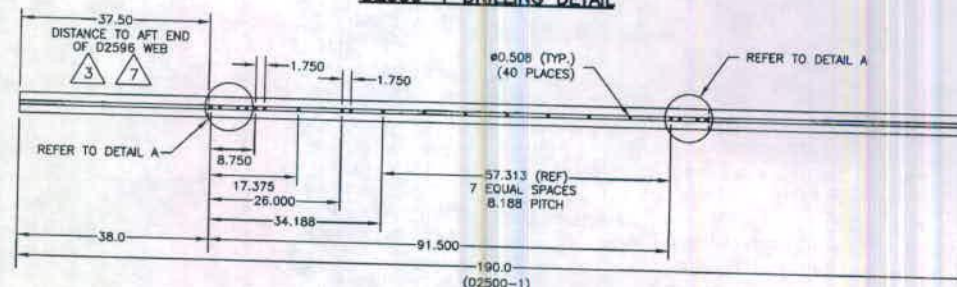
DETAIL C
SCALE 5:24



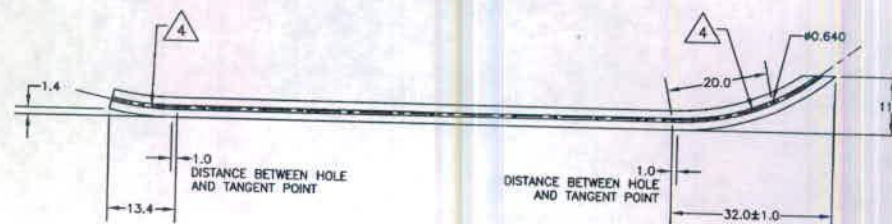
SECTION D-D
SCALE 5:24



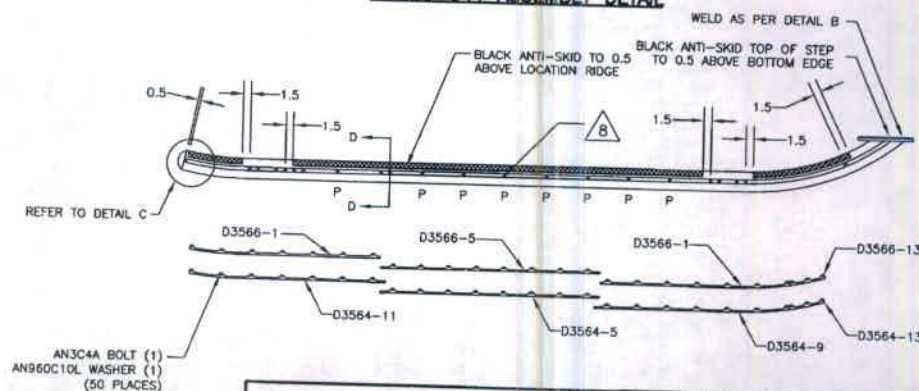
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- 1) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE		D2580	SHEET 2 OF 3
07.02.27		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

NO. 227

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Bardley Elliott
Job number: 56925
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Paul Smith Date of Test Coupon 10-03-19

Welder Bardley Elliott Date of Test Coupon 10-03-19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

